

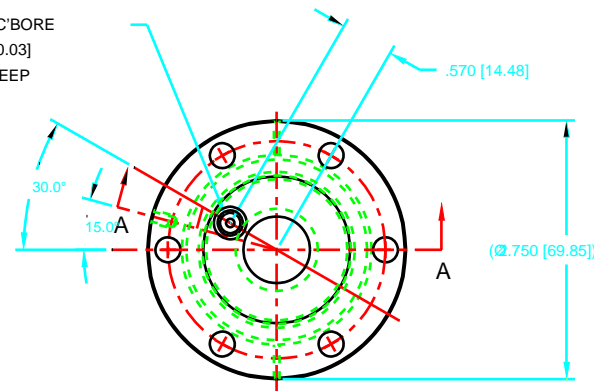
(C)

PLOT SCALE: 1=1

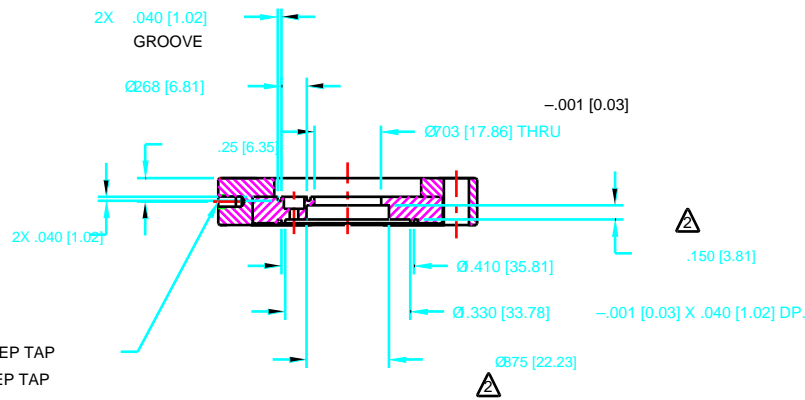
DWG. SCALE: 1

A2412700

Ø90 [2.29] THRU C'BORE
Ø18 [5.54] - .001 [0.03]
X .13 [3.30] DEEP



Ø106 X 1/4 DEEP TAP
#6 - 32 X 3/16 DEEP TAP



NOTES:

1. MAKE FROM MDC'S ROTATABLE VACUUM FLANGE CAT. #100008
2. WHEN MACHINING VACUUM PARTS, USE OF SILICONE AND SULPHUR-BASED CUTTING FLUIDS IS PROHIBITED. USE ONE OF THE FOLLOWING:
A) CIMCOOL 5 STAR 49
B) TRIM SOL
3. THIS IS A UHV PART, ELECTROPOLISHING IS NEEDED BEFORE WELDING. PRIOR TO ELECTROPOLISHING, THE PART MUST GO THROUGH A MULTIPLE STEP CLEANING PROCESS INVOLVING DEGREASING, WASHING AND DRY NITROGEN BLOW DOWN.
4. KEEP THE PART CLEAN, AND WRAP FOR UHV PACKING WITH ALUMINUM FOIL.
5. DIMENSIONS IN [] ARE MILLIMETERS AND FOR REF. ONLY

2	Ø75 [22.23] & .150 [3.81] ADDED	M.J.M.		
1	#6 - 32 TAPPED HOLE ADDED	M.J.M.	J.B.	2/4/97
SYM	CHANGE DESCRIPTION	BY	CHKD	DATE
REVISIONS				

ITEM	DWG/PART NUMBER	NOMENCLATURE OR DESCRIPTION	MATERIAL / SPEC	QTY
PARTS LIST				
UNLESS OTHERWISE SPECIFIED: ALL DIMENSIONS ARE IN INCHES		LOG NUMBER L2910205-02		
TOLERANCES		THIS DRAWING IS THE PROPERTY OF ARGONNE NATIONAL LABORATORY		
DECIMALS		DRAWN BY MUSCIA		
ANGULAR		DATE 10/12/96		
X - .03 [0.7620]		CHIEF DESIGN ENGINEER D. SHU		
XX - .01 [0.254]		DATE 6/23/96		
XXX - .005 [0.127]		GP LEADER T.M. KUZAY		
SURFACE ROUGHNESS		PROJECT MGR. D. SHU		
REMOVE ALL BURRS AND BREAK SHARP EDGES .03 MAX.		APPROVED/RELEASED		
SURFACE TEXTURE TO BE IN ACCORDANCE WITH LATEST ANSI B46.1		MATERIAL SEE NOTE #1		
DIMENSIONING & TOLERANCING IN ACCORDANCE WITH LATEST ANSI Y14.5		SCALE 1:1		
DO NOT SCALE DRAWING		SIZE C		
		DRAWING NUMBER L2-910205-02		

ADVANCED PHOTON SOURCE
L2-90 "PINK BEAM"
SLIT/BPM WATER COOLED
SLIT VACUUM FLANGE